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Title in German of the object of the invention:

*Verfahren und Anlage zur Herstellung von Pralinen*

### METHOD AND APPARATUS FOR THE PRODUCTION OF CHOCOLATE CREAMS

#### Description

The invention pertains to a method for the production of chocolate creams [creme-chocolatée] [“Translates” note: *Praline* in German = chocolate cream, defined as: “small piece of confectionery (candies), having chocolate filling &

coating of nougat, nougat, cream, liquor, cognac, or fruits) whereby a cream-like filling mass on a conveyor belt is placed upon a base material, and sealed with it, and whereby the preliminary (initial) product of the cream-like filling mass and the base material - after a cooling - are coated with a chocolate coating. The base material consists of, e.g., nougat, truffle mass or similar, or are embodied in a piece of fancy pastry (baked ware), e.g., wafer. They can have shape and size. The chocolate cream filling is most often prepared in a so-called shaping (forming or molding) jigger, or fed into the latter, and with the help of the shaping jigger placed upon the base material. The most various cream-like filling masses are known as "chocolate cream fillings". They can also be pronouncedly sticky. Henceforth, the invention pertains to a apparatus for the carrying out of such a method.

Within the framework of the measures, known in the practice, which form the point of departure of the invention, the conveyor belt is flat belt. The base materials are made beforehand, and are placed on the conveyor belt. In doing so, there originate assignment problems. Also, the chocolate cream filling, which is placed in the base material, should have a preset consistency, and may not be too pronouncedly sticky; otherwise an automated production process is scarcely ever possible. Moreover, in the case of known method, short cycle times and, therefore,

high-potential outputs per unit time may not be achieved.

The objective to execute the method, described at the beginning, in such a way that a positioning of prefabricated base materials on the conveyor belt is not anymore required, so that the work can be accomplished with high efficiency at short cycle times, forms the basis of the invention.

In order for the set objective to be achieved, the invention teaches that the work can be carried out with a conveyor belt, which has recessed base-product (couplers) mold beds, that a base-product mass is fitted into the base-product mold beds, as well as, the base-product mass is introduced into the base-product beds in order to be solidified, and that - after that - on the same conveyor belt, the chocolate cream filling is placed upon the base material, as well as the base materials together with the chocolate cream filling, placed thereon, is detached from the base-product beds, if required as the issue under consideration permits, to a chocolate cream filling mats, which, was heated, the preliminary finished product is coated, and then the same is removed from the base-product bed. To this end, an active cooling can also be carried out. Pursuant to a preferred embodiment of the invention, the conveyor belt is heated prior to the filling of the base-product mats, and - related - normally slightly heated, in order to guarantee that the base materials must be uniform, distributed in the base-product beds. To this end, the conveyor belt -

over the course of its charging, or immediately after the putting on of the raw material mass - can be subjected to a vibration. It is understood that the vibration can also be carried out over a longer time period. The cooling of the bare material mass is functionally carried out in a cooling channel, through or across, which the conveyor belt passes. Correspondingly, the work can be done when the preliminary (initial) product is cooled.

Conveyor belts, having reversed mould beds - also for the imparting of a shape *in form* to food product - are known in the abstract. It is understood that the beds of the entire belt - also within the framework of the invention - can also be normally pretreated, in order to be guaranteed that the initial product can clearly be detached from the form beds.

The invention and a apparatus for the carrying out of the method thus described

are circumstantially elucidated by means of a single drawing, which diagrammatically represents solely one exemplified embodiment. In the drawing

Fig. 1 is a side view of a apparatus for the carrying out of the method in accordance with the invention;

Fig. 2 is a top view upon the object of the invention, as depicted in Fig. 1

The apparatus, diagrammatically represented in the figures, possesses a

driven conveyor belt 1, having base material beds 2, an automatically operated apparatus 3 for the feeding of the base material mass 4 into the base material beds 2, through or across which the conveyor belt 1 passes, and an automated shaping(forming or molding) jigger 5 for the placing of the chocolate-cream filling 6 upon the base material 4. There is also connected a cooling apparatus 7 having a apparatus - connected in series - for the removal of the initial product out of the base material 4, and the chocolate-cream filling 6 from the conveyor belt 1. The conveyor belt is steered in an zig-zag manner, and is also driven at a time cycle at the apparatus 3 for the insertion of the base-product mass 2 into the base-pendulum bed 2, as well as the automated shaping(forming) jigger 5.

In accordance with the invention, the conveyor belts are not anymore used in conjunction with the production of chocolate creams. The work is rather carried out with a conveyor belt 1, which has received base material mold beds 2. These are diagrammatically represented in Fig. 2 as circles. There are filled with the help of the automatically operated apparatus 3 for the filling of the base material mass 4 into the base material beds 2. The base material beds, filled in such a way, are characterized in Fig. 2 by means of a simple hatched in the drawing. They pass through a cooling channel 7a. The conveyor belt 1 passes henceforth across an automated shaping (molding) jigger 5. With the help of the latter, the

chocolate-cream fillings 6 are put onto the base materials 4, which, in doing so, - as always - are located in the base material mold bed 2. As far as that goes, the chocolate-cream fillings 6 do not directly get in contact with the conveyor belt, and, indeed - as far as possible - also with the edge of the mold bed 2. In Fig. 2, the base materials 2 together with the chocolate-cream filling 6, placed on them, are diagrammatically represented by double hatches. In the subsequent cooling direction 1b, there occurs such a comprehensive cooling that the base products 4 together with the chocolate-cream fillings 5 are detached from the base material beds 2. They are discarded in the exemplified embodiment. The base material beds 2 are - in convention terms - free. In order to be again re-filled in the way described.

#### Patent Claims

1. Method for the production of chocolate creams [cream chocolates] whereby a chocolate-cream filling of a cream-like filling mass on a conveyor belt 1, placed upon a base material, and unified with it, and whereby the preliminary initial product of the cream-like filling mass and the base material - after a cooling - are coated with a chocolate coating, characterized in that the work is done with

the help of a conveyor belt, which has received base-material mold-belts, that may the base-material mold-belts there is injected a base-material mass, as well as base-material mass is brought in the base-material belt, in order to be solidified, and that - after that - on the same conveyor belt, the chocolate-creams filling is put upon the base materials, as well as the base material together with the chocolate-creams is detached from the base material mold-belt.

2. Method, as claimed in claim 1, characterized in that the conveyor belt is heated up prior to the filling up or injection of the base material mass.

3. Method, as claimed in claim 1 or 2, characterized in that the conveyor belt - when the filling up takes place, or directly after the filling of the base material mass - is subject to a vibration.

4. Method, as claimed in one of the claims claim 1 thru 3, characterized in that a cooling of the base material mass is carried out in a channel, through or across which the conveyor belt passes.

5. Apparatus for the carrying out of the method, as claimed in one of the claims 1 thru 4, characterized by - a division the conveyor belt (1), having base-material mold-belts (2),

- an automatically operating device (3) for the filling of the base material mass (4) into the base material mold heads (2);
- a cooling channel (7a), across or through which the conveyor belt passes, and
- an automated shaping (molding) jigger 5 for the putting on of the chocolate-cream filling (6) upon the base-material body (4),
- a cooling device (7b), having a device - connected in series - for the removal of the preliminary (initial) product (6) out of the base material (4), and the chocolate-cream filling (6) from the conveyor belt (1), whereby the conveyor belt (1) is guided in an outlet's manner, and, also, the device (3) for the filling up of the base product mass (4) into the base product mold heads (2) as well as the automated shaping (molding) jigger 5 are operated at a time cycle

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